

Work Order ID 140771

140771

Page 1

Monday, January 18, 2016 10:04:55 AM

Item ID: D3015-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

JAN 21 2016

Stop *NS2*

Item Name: Locknut

Start Date: 1/18/2016 Start Qty: 25.00

~~*25*~~ ~~*25*~~ DAS 13 9-89

Cust Item ID:

Required Date: 1/18/2016 Req'd Qty: 25.00

Customer:

Reference:

Approvals: Process Plan: MLS Date: JAN 18 2016

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3015	Rev C

100

0.00

100

PURCHASING

DAS
13
9-89

JAN 21 2016

50

Purchasing

Memo

0.00

Purchasing

Issue P/O: 31097

Description: SS locknut with nylon insert

Possible Supplier: Acklands P/N: PFS LNNC516S1

Material release note required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.01

Packaging

Ensure Material Release Note is attached

50x 8016-01-25

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

50

DAS
38
9-89

JAN 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 140771

140771

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Monday, January 18, 2016 10:04:55 AM

Item ID: D3015-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Locknut
 Start Date: 1/18/2016 Start Qty: 25.00 *25* Cust Item ID:
 Required Date: 1/18/2016 Req'd Qty: 25.00 *25* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>Sto2SA</u>	0.00							
130									
Packaging	Memo	0.00		SO		045 0 9-89		JAN 26 2016	
Packaging									
140	QC21 - Final Inspection - Work Order Release	0.00							
140								JAN 27 2016	
QC	Memo	0.04							
Quality Control									

ML5 JAN 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, January 18, 2016 10:04:59 AM

Page 1

Work Order ID: 140771

140771

Parent Item: D3015-3

D3015-3

Parent Item Name: Locknut

Start Date: 1/18/2016

Required Date: 1/18/2016

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP: A01.06.28New IssueSM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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PFS-LNNC5/16S1

Purchased

No

110

Each

0.0000

1

25

PFS-I NNC5/16S1

Lock Nut

50 x 8p/6-01-25

DQA: _____ Date: _____



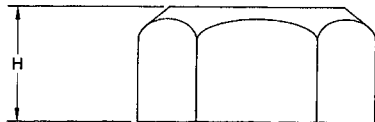
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

SPECIFICATION CONTROL DRAWING



D3015-X LOCKNUT

PART NUMBER	SIZE	HEIGHT H	POSSIBLE SUPPLIER
D3015-1	1/4-20 UNC	0.31	ACKLANDS, P/N PFSLNNC14S1
D3015-3	5/16-18 UNC	0.34	ACKLANDS, P/N PFSLNNC516S1
D3015-5	7/16-14 UNC	0.46	ACKLANDS, P/N PFSLNNC716S1
D3015-7	M5	0.19	ACKLANDS, P/N FLMN021-005-0000



NOTES:

- 1) MATERIAL: SS LOCKNUT WITH NYLON INSERT
- 2) FINISH: N/A
- 3) TOLERANCES: ALL DIMENSIONS SHOWN AS REFERENCE
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

140731
16-01-18

RELEASED
09/07/15

C	REFORMAT DWG. -7 P/N NOW FLMN021-005-0000 WAS LNNMSS1 (ZN B8-1), PAR 09-020	CP	09.07.08
B	ADD D3015-7	KJ	03.07.15
A	NEW ISSUE	DS	01.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3015** REV. C
SHEET 1 OF 1
TITLE **LOCKNUT** SCALE NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31087**

Purchase Order Date 1/21/2016

PO Print Date 1/22/2016

Page Number 1 of 2

Order From :

ACKLANDS - GRAINGER INC.
P.O. BOX 2970
WINNIPEG, MB R3C 4B5
CA

VC-ACK001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Vendor Phone 613 632 2739

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	AD62ABS	rivet	1/26/2016 Yes 1/26/2016		100.00 Each	\$0.02	\$2.19
Line Total:							\$2.19
2	PFS-LNNC14S AS PER DWG D3015 REV. C B140774	SS Locknut	1/26/2016 Yes 1/26/2016	FN	50.00 Each	\$0.15	\$7.56
Line Total:							\$7.56
3	PFS-LNNC5/16SI ✓ AS PER DWG D3015 REV. C B140771	Lock Nut	1/26/2016 Yes 1/26/2016		50.00 Each	\$0.20	\$10.14

Note:

1/22/2016

Sp/6-01-25

**ACKLANDS
GRAINGER.**ACKLANDS - GRAINGER INC.
3020 HAWTHORNE ROAD
OTTAWA ON K1G 3J6
(613) 744-5012FACTURE
Z
AB
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TO
DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY ON
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PO BOX 2970

WINNIPEG MB R3C 4B5

DART AEROSPACE LTD
DART AEROSPACE LTD VMI
1270 ABERDEEN ST
HAWKESBURY ON
K6A 1K7PACKING SLIP ONLY
INVOICE TO FOLLOWPACKING SLIP#
1451 0284663

1

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PAGE NO
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NO. DU CLIENT CUST. NO. 172628		NO. DE REFERENCE DU CLIENT CUST. REF. NO. 31087		NO. DE LICENSE PROVINCIALE P.S.T. LIC. NO. N/A - HST		NO. DU CONTRAT CONTRACT NO.		EXP. DIRECTE DIR. SHIP N		DATE DE LA COMMANDE ORDER DATE 01/21/2016		DATE DE LA FACTURE INVOICE DATE 01/22/2016											
VENDEUR SALESPERSON Q01		TERMES TERMS *** NET 30 ***		NO. DE VERSEMENTS NO. OF PMTS. 0		M.E.P. M.B.P. 0		DATE DU PREMIER VERSEMENT FIRST PAYMENT DATE 00/00/0000 16:30		APP. DE CREDIT CREDIT AUTH		S'APPLIQUE AU NO. DE FACTURE APPLY TO INVOICE NO.		RC/ B.O./SUB.		COPIES		T.P.S.G.S.T.					
ORDRE DE COMMANDE ORDER SEQ.		CODE DU MAN. MFG CODE		NO. DE PIECE ITEM NO.		PRIX DE LISTE SUGG. LIST		QUANTITE COMMANDEE QUANTITY ORDERED		QUANTITE EXPEDIEE QUANTITY SHIPPED		CODE DE COM. DIF. B.O. CODE		UNITE DE MESURE DE COMMANDE ORDRE UNIT OF MEASURE		PRIX PRICE PAR PER ESC DIS		PRIX EXTENSIONNE EXTENDED PRICE		T. P. S. T.			
ORDRE DE TABLETTE BIN LOCATION				DESCRIPTION																			
				CHANHTAL LAVOIE 613-632-9577																			
				POP AD62ABS RIVET ALUM/ALUM MAND O-E DOME		100		0		B EA		16.84 100				0.00		NYY					
				FPB U51738.025.0001 12.11 LOCKNUT NY RGL SS304 UNC 1/4-20		50		50		EA		7.56 100				3.78		NYY					
				PFSLNNC14S1 SUPERSEDED BY ABOVE ITEM																			
				FPB U51738.031.0001 16.25 LOCKNUT NY RGL SS304 UNC 5/16-18		50		50		EA		10.14 100				5.07		NYY					
				PFSLNNC516S1 SUPERSEDED BY ABOVE ITEM																			
				--- 9840 DELIVERY SERVICE		1		1		EA		7.95 1				7.95		NYY					
				HST# 88970-1272/TVQ# 1019602903																			
																SOUS TOTAL / SUB TOTAL		16.80					
				EXPEDITEUR SHIP VIA COURIER-AGI PAYS		FACT DUTY SHIP TAX		EXPENSE COM SHIP COMPLETE		PORT PAYE PPD FREIGHT		DATE DE LIVRAISON REQUISE REQUESTED DELIVERY		COMMANDEMENT BILL OF LADING		CODE DE COM. DIF. B.O. CODE B - B.O. COMMANDE DIF. C - ANNULEE CANCEL D - EXP. DIRECTE DIR. SHIP		9275 9305		T.P.S./T.V.Q. O.S.T./A.S.T. TAUX PROV. PROV. TAX		2.18 0.00	
				RECU PAR RECEIVED BY																18.98			
																				MONTANT TOTAL TOTAL AMOUNT			

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CUSTOMER COPY

5016-01-25